

Date: Wednesday, 9/13/2006 4:30:47 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28529
Estimate Number : 10678
P.O. Number : N/A
This Issue : 9/13/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 28165
Written By :
Checked & Approved By :
Comment : EST. REV. A 05.11.17 NEW ISSUE EC

Drawing Name : STRUT WELDMENT ASSY
Part Number : D3443043
Drawing Number : D3443 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 10/5/2006
Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34437 Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-7	TUBING	B28187

PD 06-10-27 (2)

2.0 D34433 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-3	CLEVIS	B28185

PD 06-10-27 (2)

3.0 238805 SS DOWEL PIN 3/4" LONG



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	238-805	SS DOWEL PIN 3/4" LONG	M19080

PD 06-10-27 (2)

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg D3443

PD 06-10-27 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/11/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:30:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 28529

Part Number: D3443043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

10/10/30 (2)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask holes as per dwg D3443

M101575

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

yl 06/10/31 x 2

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/11/31 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57935 06/10/31 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/01

Job Completion



u 06/11/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

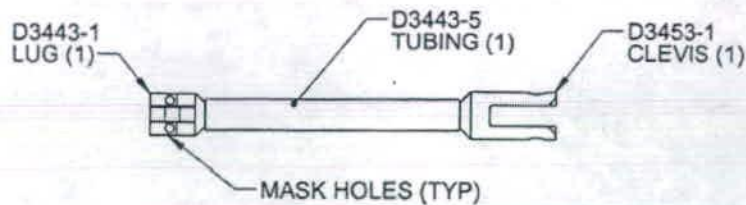
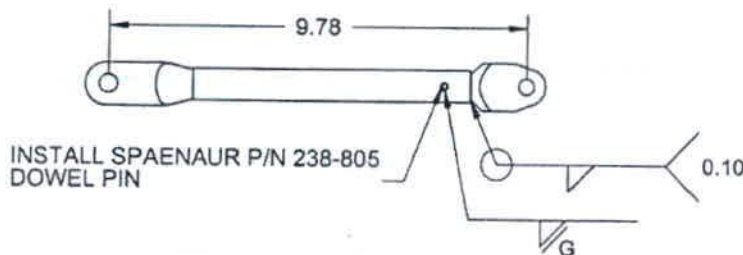
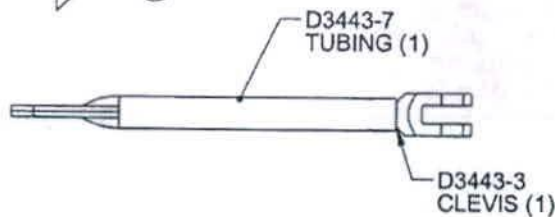
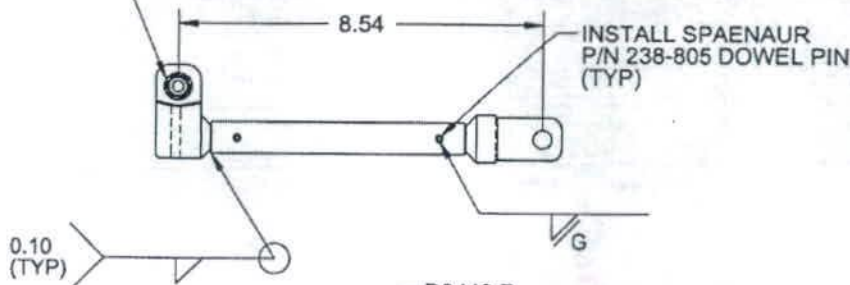
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

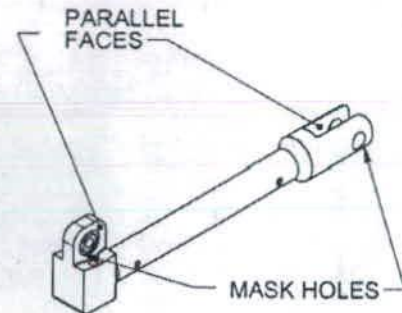
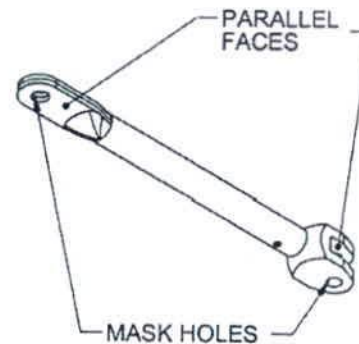
NOTE: Date & initial all entries

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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø 0.125 WAS #30	

RELEASED05.12.09 *H*PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D3443-041****D3443-043**

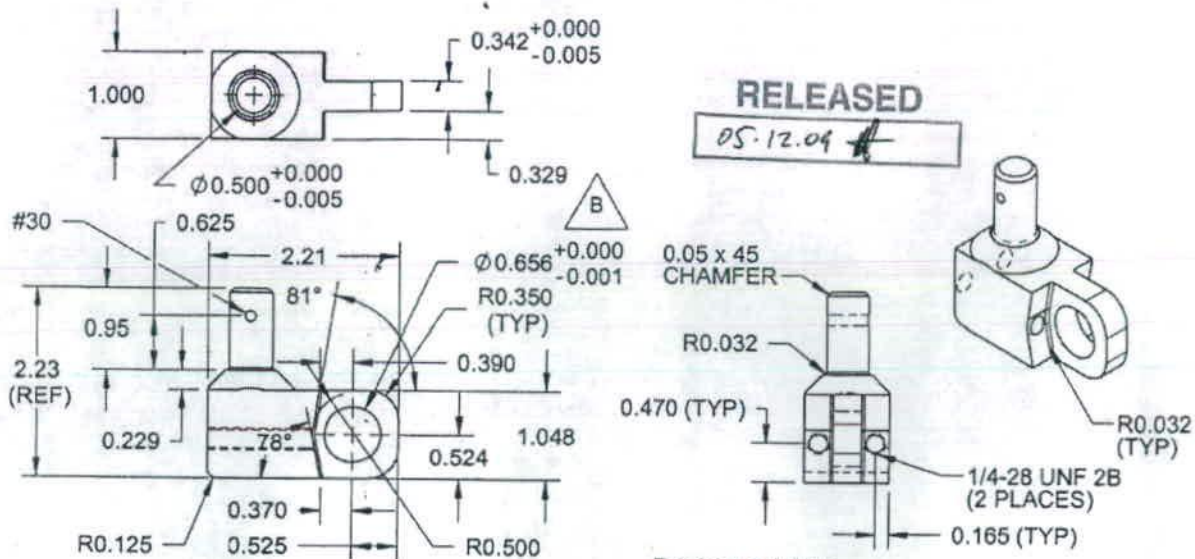
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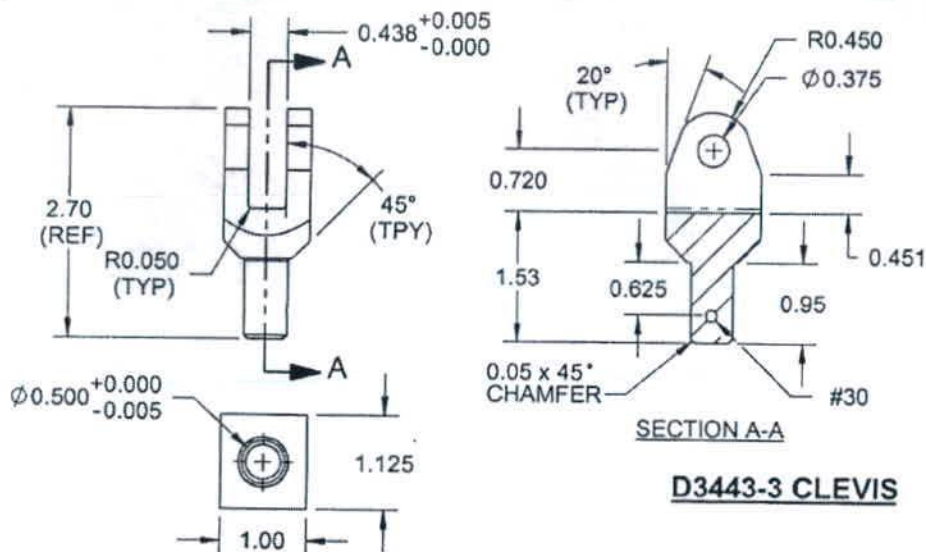
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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 12		

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

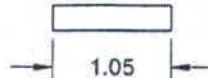
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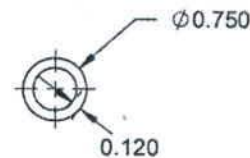
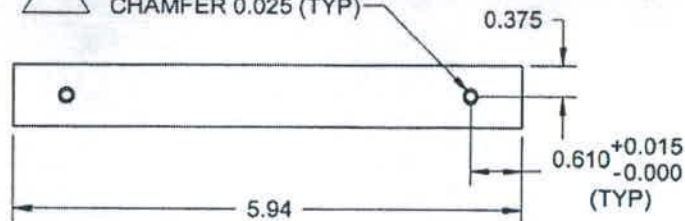
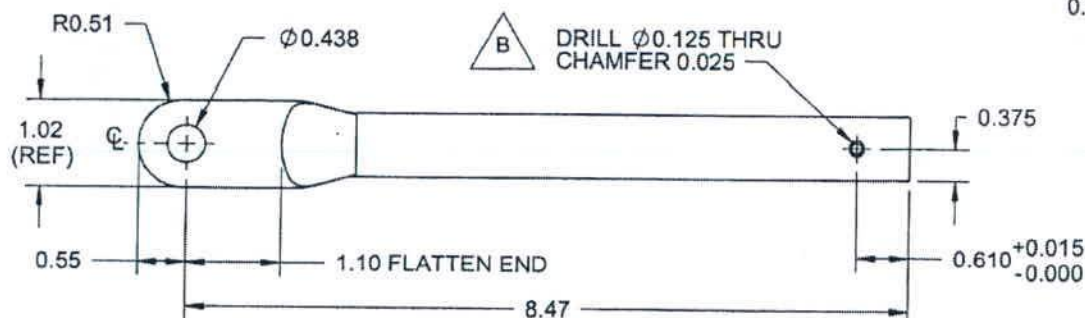
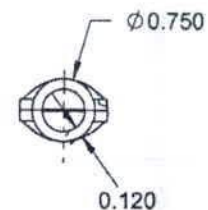
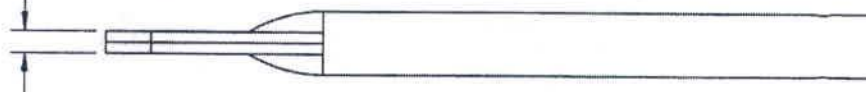
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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

 $\phi 0.210^{+0.005}_{-0.010}$ **D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.05

DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)**D3443-5 TUBING** $0.260^{+0.000}_{-0.030}$ **D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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